

# Work Order ID 68243

Monday, April 11, 2011 8:27:54 AM



Page 1

Item ID:	D3137-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	4/11/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/14/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11/04/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3137	Rev F								

100		BAND SAW	0.00						
	Bandsaw	Memo	0.00	ent 11/04/12		6	0		
	Jcaspa Bandsaw	Cut blanks: (.500" x 2.000") 5.570" long							

110		HAAS CNC VERTICAL MACHINING #1	0.00						
	HAAS 1	Memo	0.00	ent 11/04/15		5	1		
	HAAS CNC vertical machine #1	1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7 2-Deburr 3-Scribe batch number							

120		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00	ent 11/04/15		5	1		
	Quality Control								

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3137-043 PAR #: HA Fault Category: machining NCR: Yes No DQA: HA Date: 11.05.06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/05/06

NCR: <u>68243</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/04/28</u>	<u>110</u>	<u>1 part scrap, the serration tool start and finish at the wrong position.</u> <u>R.L. operator error take wrong jig. LOP</u>	<u>[Signature]</u> <u>05/4/28</u>	<u>scrap and destroy</u> <u>no replace</u>	<u>OK</u> <u>11/04/28</u>	<u>[Signature]</u> <u>11-04-28</u>	<u>[Signature]</u> <u>09/04/28</u>	<u>[Signature]</u> <u>11-04-28</u>

NOTE: Date & initial all entries

**Work Order ID 68243**

Monday, April 11, 2011 8:27:54 AM



Page 2

Item ID: D3137-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 4/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

JL 11/04/08



QC

Memo

0.00

Quality Control

x5 (x6)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3137-043 as per Dwg D3137

9511/05/03 (5)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

811/05/03

(x5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68243**

Monday, April 11, 2011 8:27:54 AM



Page 3

Item ID: D3137-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 4/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 235B

0.00



Packaging

Memo

0.00

Packaging

10/4/4 (5)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/4 (5)11-05-4  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 11, 2011 8:28:01 AM

Page 1

Work Order ID: 68243

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A 04.02.18 New issue KJ/DS  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101  Screw		Purchased	No			100	Each	31.0000	1	6		4/5/03	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST290A				31					
				110363				31					
D3137-3  Guide		Manufactured	No			140	Each	26.0000	1	6		4/5/03	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST235B				26					
				67064				26					
D3137-5  Washer		Manufactured	No			140	Each	9.0000	1	6		4/5/03	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST235B				9					
				67015				9					

B68262 (3x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

Monday, April 11, 2011 8:28:01 AM

Work Order ID: 68243



Parent Item: D3137-043



Parent Item Name: Bracket Assembly

Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 6.00

Required Qty: 6.00

M174B0.500X02.000

Purchased

No

140

f

57.6000

0.4643

2.932421



17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT050

57.6

100843

12.9

103089

13

14932

23.8

→ 19572

7.9

2.93 *ml 11/04/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68243
<b>Description:</b> Bracket		<b>Part Number:</b>	D3137-7
<b>Inspection Dwg:</b> D3137	<b>Rev:</b> F	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.560	+0.006/-0.001	0.560	✓		Vern HL7	
5.29	+/-0.030	5.290	✓		"	
2.79	+/-0.030	.760	✓		"	
0.67	+/-0.030	.700	✓		"	
1.90	+/-0.030	1.888	✓		"	
0.262	+/-0.010	.262	✓		"	
0.062	+/-0.010	.063	✓		"	
4.850	+/-0.010	4.850	✓		"	
0.162	+/-0.010	.158	✓		"	
Ø0.500	+0.006/-0.001	0.506	✓		"	
2.360	+/-0.010	2.360	✓		"	
1.880	+/-0.010	1.880	✓		"	
0.480	+/-0.010	.477	✓		"	

<b>Measured by:</b>	aml	<b>Audited by:</b>	SL	<b>Preliminary Approval:</b>	N/A
<b>Date:</b>	11/04/15	<b>Date:</b>	11/04/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev updated	KJ/JLM	
D	08.12.02	Dwg Rev updated	KJ/DD	
E	10.08.03	Dimension 5.29 was 0.529	KJ	11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

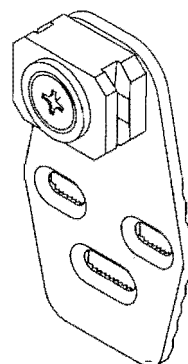
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

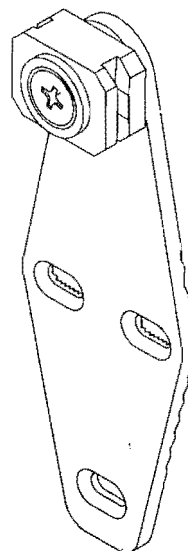
**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68243

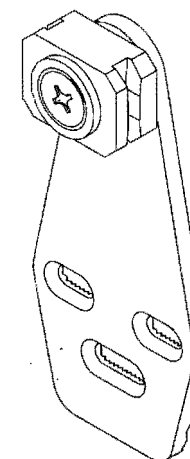
*M11104-11*



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**RELEASED**  
08.06.2004

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.3 0.67 DIM WAS 0.79, ZONE B.5 4.860 DIM WAS 4.975 & ZONE B.6 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

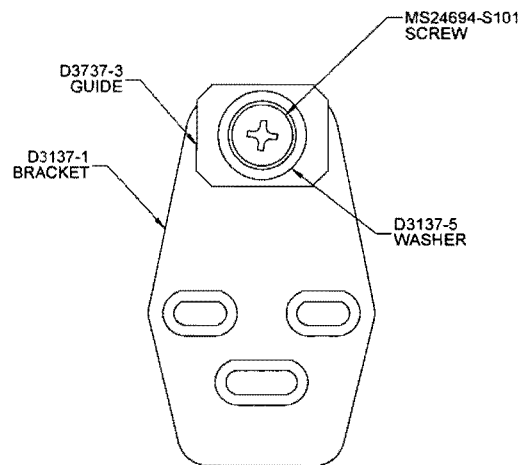
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

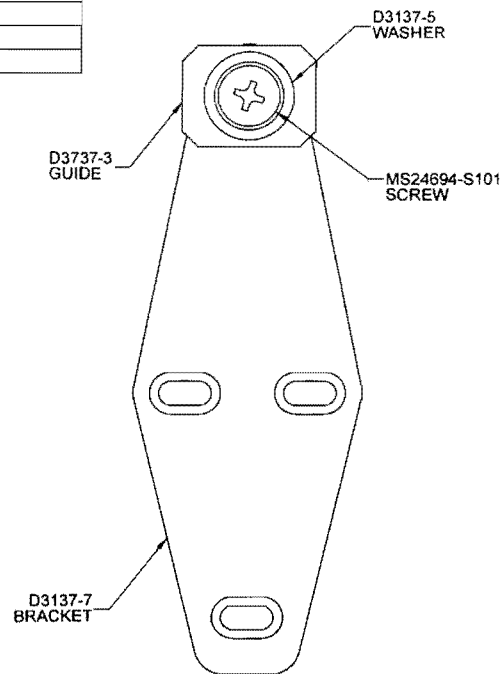
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

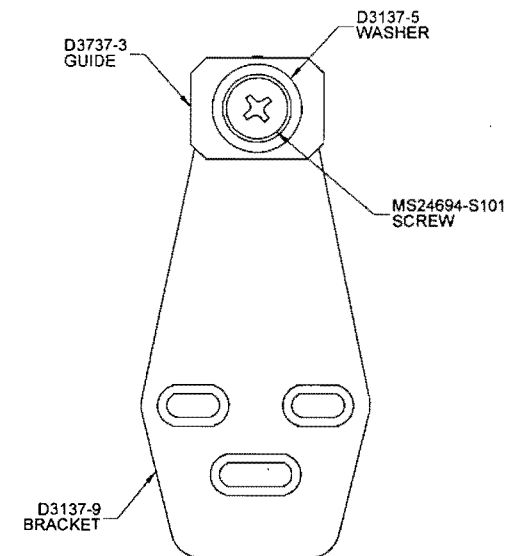
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

**RELEASED**  
08-06-16/11

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

u/o 68243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

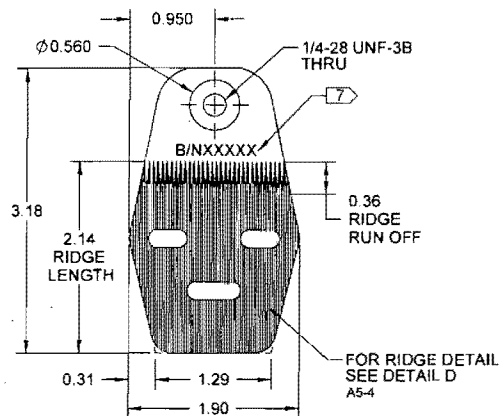
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

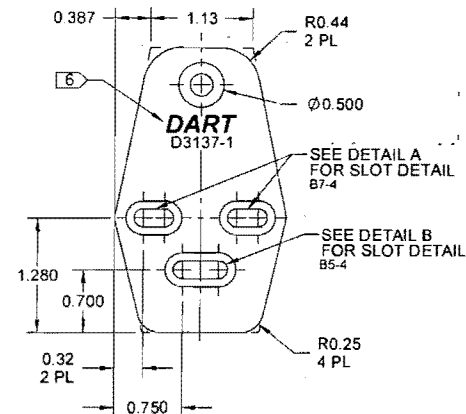
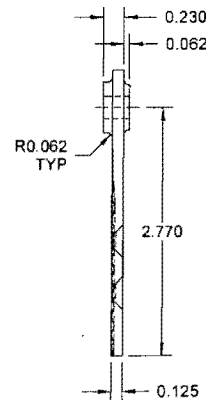
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

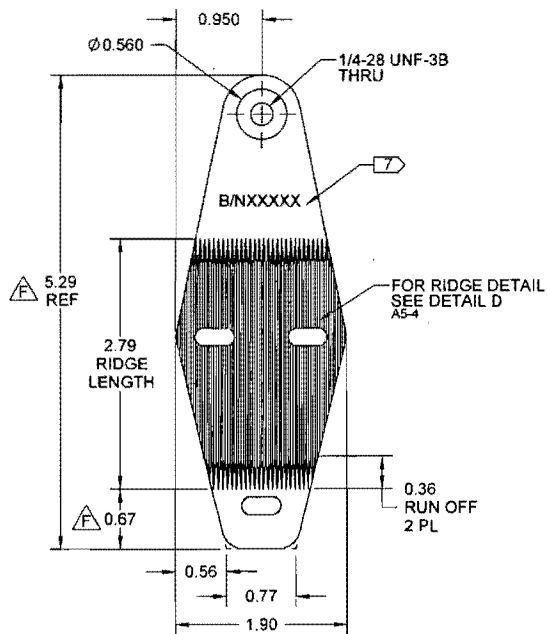




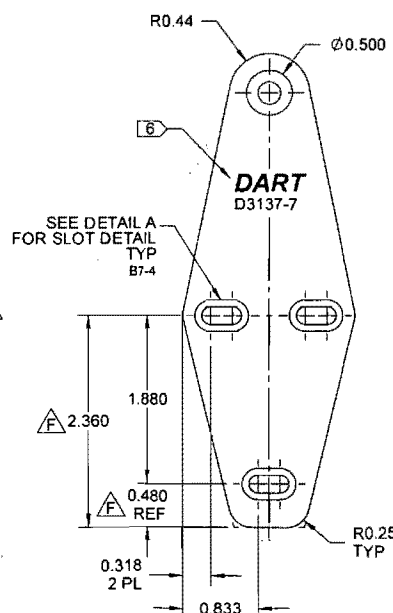
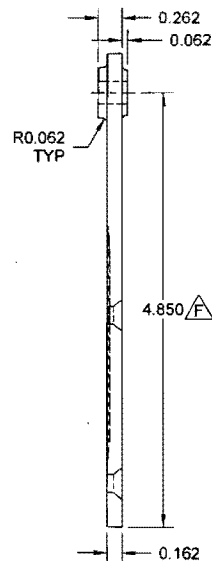
**D3137-1 BRACKET**



w/0 48243






**D3137-7 BRACKET**



- NOTES:**
- 1) MATERIAL: -1 & -7  
17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
  - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
  - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
  - 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

**RELEASED**  
08-06-26

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D3137</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET ASSEMBLY</b>	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

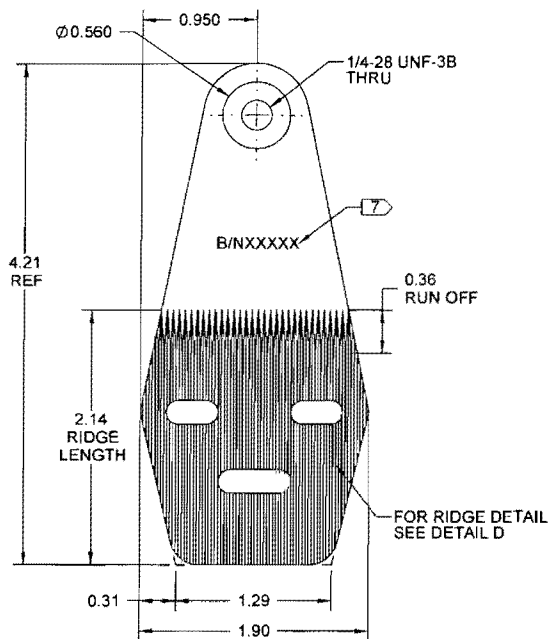
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

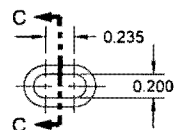
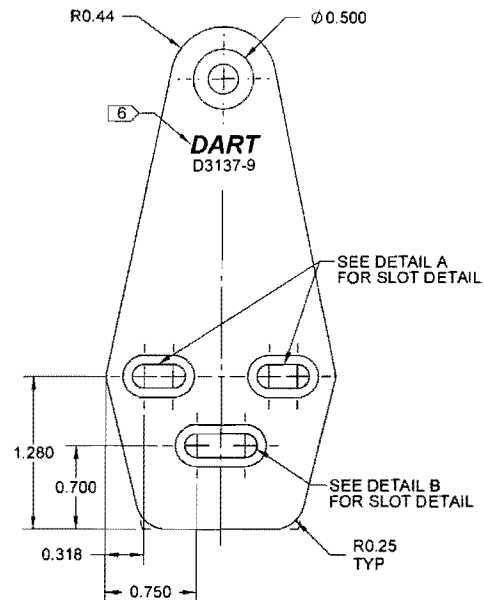
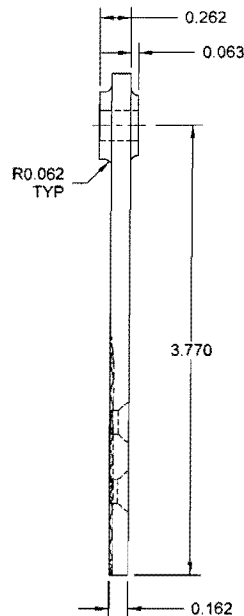
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

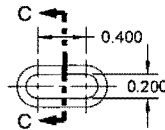
**NOTE:** Date & initial all entries



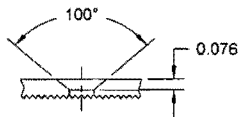
**D3137-9 BRACKET**



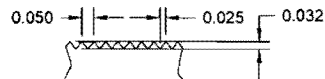
**DETAIL A**  
(SLOT DETAIL)



**DETAIL B**  
(SLOT DETAIL)



**SECTION C-C**  
(SLOT DETAIL)



**DETAIL D**  
SCALE 2X  
(TYPICAL RIDGE DETAIL)

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

**RELEASED**  
08.06.30

*W/L 68243*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

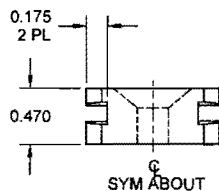
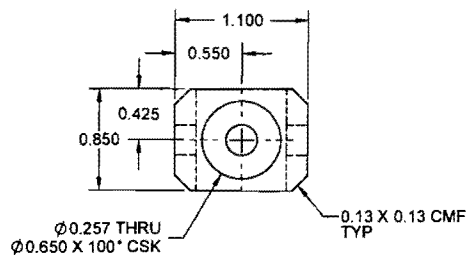
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

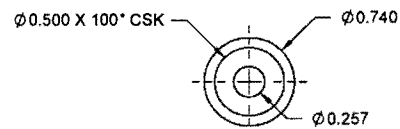
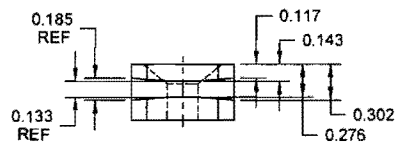
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

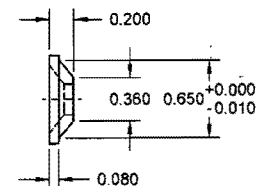
8 7 6 5 4 3 2 1



**D3137-3 GUIDE**



**D3137-5 WASHER**



W/O 68243

**RELEASED**

**NOTES:**

- 1) MATERIAL: -3  
DELTRIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELTRIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. F
MFG. APPR.	JH	D3137	SHEET 5 OF 5
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries